

Work Order ID 163261

Tuesday, June 27, 2017 10:02:35 AM

163261

Page 1

Item ID: D4705-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pin, Quick Release
 Start Date: 6/27/2017 Start Qty: ~~10.00~~ ⁶⁰ ***10*** Cust Item ID:
 Required Date: 7/11/2017 Req'd Qty: ~~10.00~~ ⁶⁰ ***10*** Customer:
 Reference:

Approvals: Process Plan: DAS Date: JUN 27 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 21 ~~9-89~~ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4705	A

100		0.00							DAS
100									13

Purchasing Memo 0.00
 Purchasing Issue P/O: 36872
 Order as per Dwg D4705-1
 Possible supplier: Monroe
 Material release note is required

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
-----	--	------	--	--	--	--	--	--	--

110									
--------------	--	--	--	--	--	--	--	--	--

Packaging Memo 0.20
 Packaging

120	QC6- All purchased or subcontracted products	0.00							
-----	--	------	--	--	--	--	--	--	--

120									
--------------	--	--	--	--	--	--	--	--	--

QC Memo 0.00
 Quality Control

60 JUN 28 2017 **DAS**
13
9-89

60 x SP7-7-24.

60 **DAS**
38
9-89
 JUL 25 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
OTHER : ☐																									

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>5th/20</u>	0.00							
130									
Packaging	Memo	0.10				60	JUL 27 2017	DAS 6	9-80
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	1.00							
Quality Control									

17/7/28

UM 7/27/17

(Signature)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Tuesday, June 27, 2017 10:02:37 AM

Page 1

Work Order ID: 163261

163261

Parent Item: D4705-1

D4705-1

Parent Item Name: Pin, Quick Release

Start Date: 6/27/2017

Required Date: 7/11/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.08.16 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4705-1P

Purchased

No

110

Each

0.0000

1

10

D4705-1P

**

Quick Release Pin

60

60 x SP 17-7-24.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

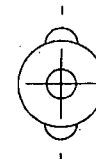
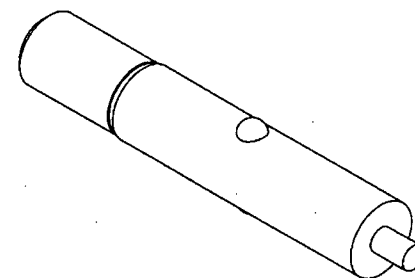
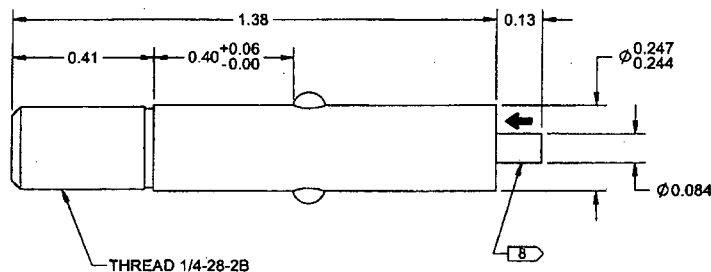
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OTHER : ☐																									

SPECIFICATION CONTROL DRAWING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *163261* *1706-27*



D4705-1 QUICK RELEASE PIN

NOTES:

- 1) MATERIAL: 17-4 PH H800/S17400 / TYPE 630 STAINLESS PER AMS 5643 / ASTM A564
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4705-1" AND B/N "BXXXXX" PER QSI 044.6.7
- 7) WEIGHT: 0.01lbs
- 8) RELEASES BALLS INWARD FLUSH OR UNDERFLUSH TO SHAFT WHEN PRESSED IN
- 9) RECOMMENDED SUPPLIER: MONROE ENGINEERING, 1030 DORIS, AUBURN HILLS, MI 48326

2012-10-12

REV.	NEW ISSUE	DESCRIPTION	RP	12.09.19
DESIGN	RP	DART AEROSPACE USA, INC.	BY	DATE
DRAWN	RP	KENT, WA		
CHECKED	<i>AS</i>	DRAWING NO. D4705	REV. A	
MFG. APPR.	<i>W</i>		SHEET 1 OF 1	
APPROVED	<i>W</i>	TITLE	SCALE	
DE APPR.	<i>W</i>	QUICK RELEASE PIN	NTS	
DATE	12.09.19	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
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OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36872

Purchase Order Date 6/28/2017

PO Print Date 6/28/2017

Page Number 1 of 2

Order From :

VU-MOP01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

MONROE PMP
1030 DORIS ROAD
AUBURN HILLS
MICHIGAN, MICHIGAN 48326
USA

E-MAILED
JUN 29 2017

Contact Name

Vendor Phone 248-292-5702

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency USD

FOB EXW - (Ex Works)

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D4705-1P	Quick Release Pin	8/28/2017 Yes 8/28/2017		60.00 Each	\$51.43	\$3,085.80
	AS PER DWG D4705 REV. A B163261						
							DAS 38 9-88
						Line Total:	\$3,085.80
2	71401-45	PROCUREMENT QUALITY CLAUSES	8/28/2017 No 8/28/2017		1.00	\$0.00	\$0.00
	PROCUREMENT QUALITY CLAUSES						
	A005 RIGHT OF ENTRY						
	A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)						
	A012 CHEMICAL AND PHYSICAL TEST REPORTS						
	A016 PERSONNEL QUALIFICATION						
	A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)						
	A026 CERTIFICATION OF MATERIAL CONFORMANCE						
	A041 QUALITY MANAGEMENT SYSTEM						
	A042 DART NOTIFICATION BY SUPPLIER						
	A043 RETENTION OF QUALITY DOCUMENT						

PO Instructions: Fedex Acc#151793240

Note:

6/28/2017



SHIPPER

2990 Technology Drive
Rochester Hills, MI 48309
TEL: (800) 440-3967
FAX: (800) 453-9683

NO RETURNS ACCEPTED WITHOUT
FACTORY APPROVAL AND RMA NO..
AUTHORIZED GOODS WITH RMA NO.
SHOULD BE RETURNED TO FACTORY
ADDRESS.

DATE 07/20/2017 SHIPPER NO. 461085 PAGE 1

BILL TO: 37223

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY ON K6A1K7
CANADA

SHIPPED TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY ON K6A1K7
CANADA

PO: PO36872

PO:

ORDER#	ORDER DATE	SHIP VIA	SHIP DATE
428190	06/30/17	FEDEX NEXT DAY: COLLECT ACCOUNT: 151793240	07/20/17
QTY ORDER	QTY SHIP	QTY BACKORDER	DESCRIPTION
60	60	0	D4705-1P QUICK RELEASE PIN, DWG D4705 LOT 153741 60 REV# A REV# A

SP 17-7-24

WE APPRECIATE YOUR BUSINESS!

DAG
38
9-89



INVOICE

Monroe PMP

2990 Technology Drive

Rochester Hills, MI 48309

TEL: (800) 440-3967

FAX: (800) 453-9683

NO RETURNS ACCEPTED WITHOUT
FACTORY APPROVAL AND RMA NO..
AUTHORIZED GOODS WITH RMA NO..
SHOULD BE RETURNED TO FACTORY
ADDRESS.

DATE

INVOICE NO.

PAGE

07/20/17

487240

1

BILL TO: 37223

SHIPPED TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY ON K6A1K7
CANADA

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY ON K6A1K7
CANADA

PO: PO36872

PO:

SHIPPER #461085

ORDER#	ORDER DATE	TERRITORY	SHIP VIA	SHIP DATE	TERMS	
428190	06/30/17	5025	F.O.B SHIPPING POINT FEDEX NEXT DAY	07/20/17	NET 30	
QTY ORDER	QTY SHIP	QTY BACKORDER	DESCRIPTION	UNIT PRICE	DSC%	NET AMOUNT
60	60		D4705-1P QUICK RELEASE PIN, DWG D4705	51.43		3,085.80
			SUB TOTAL			3,085.80
			HANDLING			4.50
			TOTAL			3,090.30
Cgo US USD currency						
SPN-7-21						

ALL PURCHASE ORDERS SUBJECT TO MONROE PMP'S TERMS AND CONDITIONS.

INVOICES PAID BEYOND DUE DATE SUBJECT TO 1.5% INTEREST PER MONTH.

WE APPRECIATE YOUR BUSINESS!

DAS
38
9-89